



P/N: D5085-1

REV: B

SERIAL: S220570

NOV 06 2019

INSP/DATE:

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T102137-111-105

Job Sheet 201268



T102137-111-105

Job Qty: 6 pcs



Status: New

Priority: Medium

Job Created: 9/30/19

Due Date: 10/28/19

Type: SOLD

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG RB T102137-111 Rev B IPP Rev. A 19.06.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	SL-154 - 1	6 pcs	10/28/19	10/28/19	1.00	1.00	SL-154 - 1	JB 19-10-24
120	QC 2	6 pcs	10/28/19	10/28/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	JB 19-10-24
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

Dart Aerospace
1270 Aberdeen St
Hawkesbury, ON
Canada
Tel: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S226185

Part: RB T102137 - 111 - 105

Job No: 201268

Serial No/Batch: S226185

Revision: B

Inspector:

Exp Date:

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62
9-89

DAS
62
9-89

9/30/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

150 QC 8	6 pcs	10/28/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
155 Outsource - 1 - Heat Treat	6 pcs	10/28/19		MEI004-VC-470012	19/10/23 DAS 23 9-8C 2019-10-28
200 Packaging 2-2 - Receive - B4B	6 pcs	10/28/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
205 QC 6	6 pcs	10/28/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	NOV 06 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
				QC 6 - 81	
210 Packaging 3-1 - Stock - B4B	6 pcs	10/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	6 pcs	10/28/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	NOV 07 2019
				QC 21 - SA - 53	9-89

Part Op 110 - MORI SL-154 LATHE - 1-Machine as per folio 5B **FD 010** *** NOTE same as RB T102137-107-105 FB844***
 Descriptions: FOLIO REV: **AA** DWG REV: **B** 2-Debur

120 - QC2- Inspect parts off machine FAI/FAIB

150 - QC8- Inspect parts - second check

155 - 1-Issue P/O; **44918** RC 48-52 2-Bead blast 3-Material type; O1 4- Certificate of Conformity is required

200 - Receive & Inspect for Damage & Mat'l Certs

205 - QC6- All purchased or subcontracted products ***NOTE*** Zinc plating to be done after load test at final assembly.

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

210 - Identify as per dwg & Stock Location:
220 - QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R0.625	Tool Steel Round Bar 0.625 dia.	2.4000 ft (.4 ea)	110-SL-154 - 1	5214384
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-O1-R0.625	2	12	0
Part Specifications				
Specifications could not be found.				

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044918



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866.257.6395

Attention: Ananth, Nimmy

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044918

PO Date: 10/28/19

Due Date: 11/5/19

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200885	RBA9829-3	RBA9829 Rev 3	Wrench 1-Issue P/O Heat treat RC 35-40 2-Bead blast 3-Apply LPS-3 rust inhibitor 4-Material type 4140 5-Certificate of Conformity is required	Firmed - X5		11/5/19	5 pcs	0 pcs	5 pcs	\$16.00/pcs	\$80.00
2	201268	RB T102137-111-105	RB T102137-111 Rev B	Pin 1-Issue P/O RC 48-52 2-Bead blast 3-Material type O1 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed - X6		11/5/19	6 pcs	0 pcs	6 pcs	\$13.3333/pcs	\$80.00
3	201269	RB T102137-111-107	RB T102137-111 Rev B	Sleeve 1-Issue P/O; Heat treat RC 32-38 2-Bead blast 3-Material type; 4140 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed - X6		11/5/19	6 pcs	0 pcs	6 pcs	\$13.3333/pcs	\$80.00

NOV 04 2019

NOV 04 2019

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Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044918



Items										Unit	Extended Price
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity		
4	199904	RBW6405G12031-3G-7	RBW6405G12031-3G Rev 3	Pull Stud 1-Issue P/O RC 34-38 2-Bead blast 3-Material type 4140 4- Certificate of Conformity is required	Firmed	-	1/5/19	8 pcs	0 pcs	8 pcs	\$12.87625/pcs
Line Item Note 3 bars = 8 cut pieces once heat treated and we cut										Grand Total	\$343.01

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program
A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Guerin

Plex 10/31/19 10:14 AM Dart.Guerin.Kimberley

Shipping Ticket

Sold To:
DART AEROSPACE LTD.
1270 ABERDEEN ST

1448

HAWKESBURY ON K6A 1K7

Ship To:
DART AEROSPACE LTD.
1270 ABERDEEN ST

168259

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
POHB044918				

Quantity	Part No. / Part Name / Part Description	Pounds
6 PCS	MATERIAL 01 BEAD BLAST AND HEAT TREAT TO 48-52RC C OF C, PRT# RB T102137-111-105, JOB# 201268	

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

6

Pounds Shipped:

2.00

RECEIVED

NOV 04 2019

DART AEROSPACE LTD.

Order No.: 171447

Shipped Complete

Quantity Shipped:

6.00

Received By:

Date:

Pounds Shipped:

2.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 10/30/2019

Certification

Date: 10/31/2019

Entry Date: 10/30/2019

Page: 1 of 1

To:

DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: POHB044918

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 01

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
6	6 PCS MATERIAL 01 BEAD BLAST AND HEAT TREAT TO 48-52RC C OF C, PRT# RB T102137-111-105, JOB# 201268	2

Insp. Type	Scale	Minimum	Maximum	Number	Other
Customer Requirements:					

Harden rockwell

Results:

Harden ROCKWE 48. 52. 52. TESTED AS PER SAMPLING PLAN

HEAT TREATED TO 52 RC AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for storage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformation, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


RICK BUGGY
QUALITY CONTROL

ATLANTIC HEAT TREATING 2001 LTD